



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D212-664-101
Job Sheet 184649



Part No: D212-664-101

Job Qty: 1 ea

Part Name: Fwd Crosstube - High



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/15/18

Job Tracking No:

Due Date: 11/8/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D212-664-141 REV E/ IIN-D212-664 REV.J IPP Rev:E 04.02.16 Reformat KJ/DS IPP Rev:F 06-03-29 Remove
Comments on Pick List JLM IPP Rev:G 07-04-30 As per Rev C JLM IPP Rev:H 11.04.26 inspection strip ecn 11-
549 EC verf by:DD IPP REV:I 14.05.27 AS PER ECN 14-570 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/8/18	0.00	0.00	Start Up Stores/Pkg-1		GP 2018-10-24
110	Packaging	1 pcs		11/8/18	0.00	0.00	Packaging1-3		GP 2018-10-24
120	CNC Bend Crosstubes	1 pcs		11/8/18	3.11	2.22	CNC Bend Crosstube		GP 2018-10-24
130	QC	1 pcs		11/8/18	0.00	0.00	QC15		38
140	Crosstubes	1 pcs		11/8/18	0.00	0.67	Crosstubes-1		GP 2018-10-29
150	HandFXtube	1 pcs		11/8/18	0.00	0.98	HandFinish5		GP 2018-10-29
160	QC	1 pcs		11/8/18	0.00	0.00	QC7-1		23
165	QC	1 pcs		11/8/18	0.00	0.00	QC5		23
170	Outsource	1 pcs		11/8/18			SKY002-VC		QC 18-11-12
180	Packaging	1 pcs		11/8/18	0.00	0.00	Packaging2		NOV 19 2018
190	QC	1 pcs		11/8/18	0.00	0.00	QC5		38
200	SprayPaint	1 pcs		11/8/18	0.00	0.25	Spray Paint		AL 18-11-16
210	QC	1 pcs		11/8/18	0.00	0.00	QC14		SA 18-11-18
220	Crosstubes	1 pcs		11/8/18	0.00	1.69	Crosstubes-1		38
230	QC	1 pcs		11/8/18	0.00	0.00	QC5		38
240	Packaging	1 pcs		11/8/18	0.00	0.00	Packaging1-3		NOV 23 2018
250	QC	1 pcs		11/8/18	0.00	0.00	QC4		NOV 23 2018
260	Packaging	1 pcs		11/8/18	0.00	0.00	Packaging3-1		NOV 23 2018
265	DC	1 pcs		11/8/18	0.00	0.00	DC		NOV 23 2018
270	QC21-FG	1 Ea		11/8/18	0.00	0.00	QC21		NOV 23 2018

Part Op 120 - Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio D212-664-101

Descriptions: 140 - "1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549, using drill table DT8577, set-up towers in hole #7 as per QSI 10 2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes. 3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141 4-*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141"

150 - ***IMMEDIATELY AFTER GRINDING***

170 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

180 - Ensure copy of NDT results attached to work order.

190 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for damage & ensure results are as per Dwg D212-664-141

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1-Prime inside & outside crosstube as per QSI

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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005 4.2 BATCH: 138962 2- After painting remove masking and apply matte clear coat per QSI005 4.2 3- MASK
 UNDERSIDE OF CROSSTUBE AS SHOWN ON DWG BEFORE PAINTING 4 -Paint Outside of Tube as per Dart QSI 005
 4.2 clear 138832 Paint 138956
 210 - Then, Wrap in plastic bag to protect from scratches
 220 - *****LAY DOWN CROSSTUBE ON TABLE AND PUT DT10302 PINS IN SADDLE HOLE FACING UP, USE HOLE
 IN TAPE MASURE TO PUT IN PINS FOR LOCATING CENTER OF CROSSTUBE. ***** 1- Abrade mating surfaces of
 support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2- Install supports with
 Proseal 890 per D212-664-141 and QSI 015 A/R Proseal 890 Batch: 5016399 EXP: EX 3/19
 PROSEAL CURE TIME 72 HOURS: Start: 18/11/18 Finish: 18/11/19 3- Install clamps
 with rubber cushion (ENSURE CLAMPS ARE INSTALL ON TOP SIDE OF CROSSTUBE) using DT9565 as per Dwg
 D212-664-141. ***Torque all clamps to 80-100 IN-LBS ***
 230 - ***RE-CHECK TORQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***
 250 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____
 260 - Identify and pack for shipping as per PPP D212-664-101 Location : FG094
 265 - Photocopy bluefile and create labels as per PPP D212-664-101 CHG006

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D212-664-101TRN	Crosstube Turning Detail	1 Ea (1 ea)	90-Start up Operation	<u>5119687</u>
D2893-1	Support	2 Ea (2 ea)	220-Crosstubes	
D3595-063-450	Rubber Cushion 0.63" Wide X 4.50" Long	4 Ea (4 ea)	220-Crosstubes	
MS21920-25	Clamp	4 Ea (4 ea)	220-Crosstubes	
AN6-35A	Bolt	4 Ea (4 ea)	240-Packaging	<u>5123681</u>
AN6-36A	Bolt	4 Ea (4 ea)	240-Packaging	<u>5098035</u>
D3428-1	Placard	1 Ea (1 ea)	240-Packaging	<u>5059483</u>
MS21042L6	Nut	6 Ea (6 ea)	240-Packaging	<u>5106102</u>
NAS1149D0663J	Washer	18 Ea (18 ea)	240-Packaging	<u>5093765</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D212-664-101TRN	1	0	0
220-Crosstubes	D2893-1 <u>5109395</u>	<u>2</u>	13	0
	D3595-063-450 <u>5127275</u>	<u>4</u>	77	0
	MS21920-25 <u>5107731</u>	<u>4</u>	172	0
240-Packaging	AN6-35A	4	55	0
	AN6-36A	4	93	0
	D3428-1	1	45	0
	MS21042L6	6	358	0
	NAS1149D0663J	18	1,106	0

Part Specifications

Dart Aerospace Ltd.
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 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

DART
 AEROSPACE

Container No: S121121



Part: D212-664-101

Job No: 184649

Serial No/Batch: S121121

Revision: E/J

Inspector:

Exp Date:

Instructions: TC STC SH01 -9 Issue 3, EA No. 6276 SR01298NY 09/01/08, EASA ST

Specifications could not be found

Print: 10/15/18 2:04 PM DartAerospace.se.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

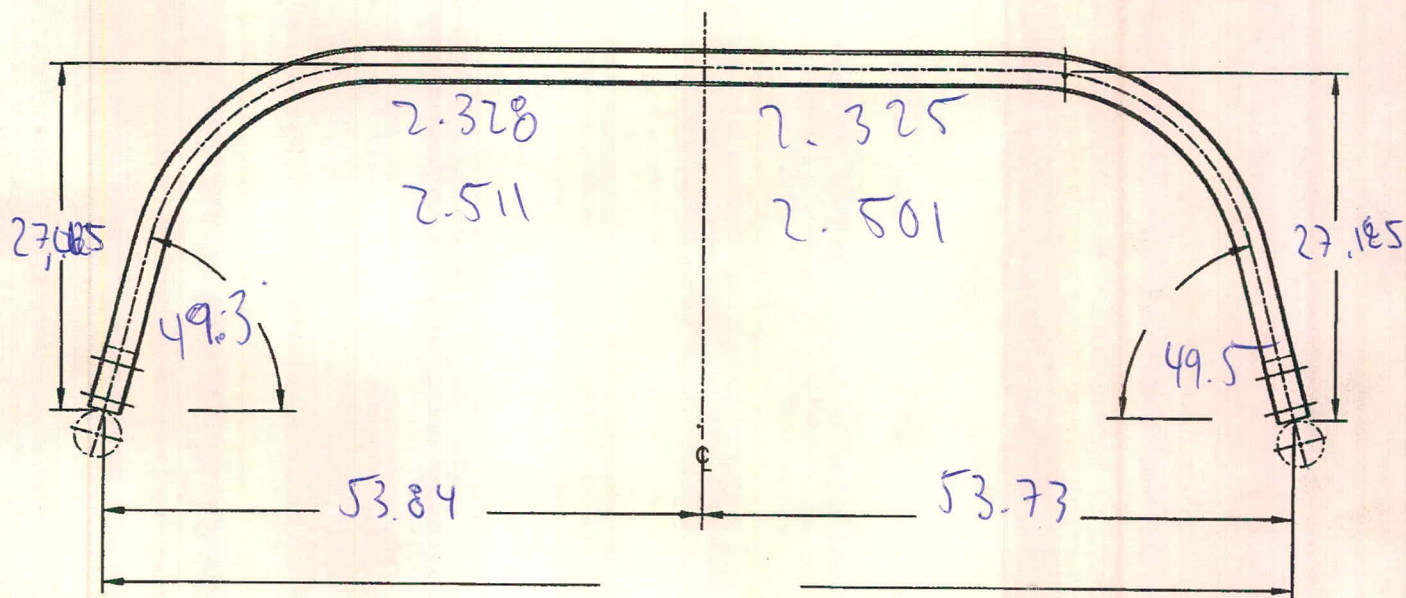
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DART AEROSPACE LTD		Work Order:	184649
Description: Crosstube High Fwd (205/212/412)		Part Number:	D212-664-101
Inspection Dwg: D212-664-141	Rev: E	Page 1 of 1	

Required Dimension	Min	Max
Height	26.67	27.17
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7
Bending Passes	3	--
Crushing	--	7.2%



	Side A	Side B
Bending Passes	3	3
Crushing	3.8%	3.6%
Comments		

QC15 Inspection	EB
Date	18-10-26

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	
C	10.04.01	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing dimensions	KJ	
E	14.07.28	Revised max crushing %	KJ	
F	16.01.15	Revised Height min/max dimensions	KJ	up

Item	Qty -141	Qty -141B	Qty -141F	Part Number	Description
1	X			D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		X		D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3			X	D212-664-141F	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD) (ANODIZED)
4	1	1	1	D6005-128	CROSSTUBE
5	2		2	D2893-1	SUPPORT
6	4	4	4	D3595-063-450	RUBBER CUSHION
7		2		D5017-1	SUPPORT
8	4	4	4	MS21920-25	CLAMP (OR MS21920-26)
9	A/R	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.514±0.020
- FINISH -141 & -141B: a) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
b) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
c) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2 / C6-3, HATCHED AREA)
d) PAINT OUTSIDE PER DART QSI 005 4.2
e) REMOVE MASKING AND APPLY MATTE CLEAR COAT
FINISH -141F: a) ANODIZE PER MIL-A-8625, TYPE II, CLASS 1.
b) ALODINE (DO NOT ETCH) PER QSI 005 4.1.2
c) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
d) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2 / C6-3, HATCHED AREA)
e) PAINT OUTSIDE PER DART QSI 005 4.2
f) REMOVE MASKING AND APPLY MATTE CLEAR COAT
***NOTE:** BETWEEN FINISHING OPERATIONS EXTREME CARE MUST BE TAKEN NOT TO CONTAMINATE OR DAMAGE FINISHED SURFACES.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS
- WEIGHT: D212-664-141/-141B/-141F = 33.6 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

MACHINING

- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.

BENDING

- BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7.2% (BASED ON O.D.) IN LOWER HALF OF R35.5 BEND AND 6% (BASED ON O.D.) ON REMAINING TUBE.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

ASSEMBLY

- TO INSTALL D2893-1 / D5017-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE ON TOP SIDE OF CROSSTUBE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 184 649 MWS
18-10-15

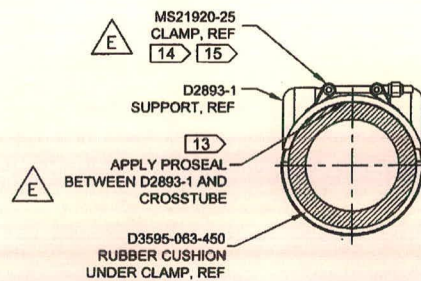
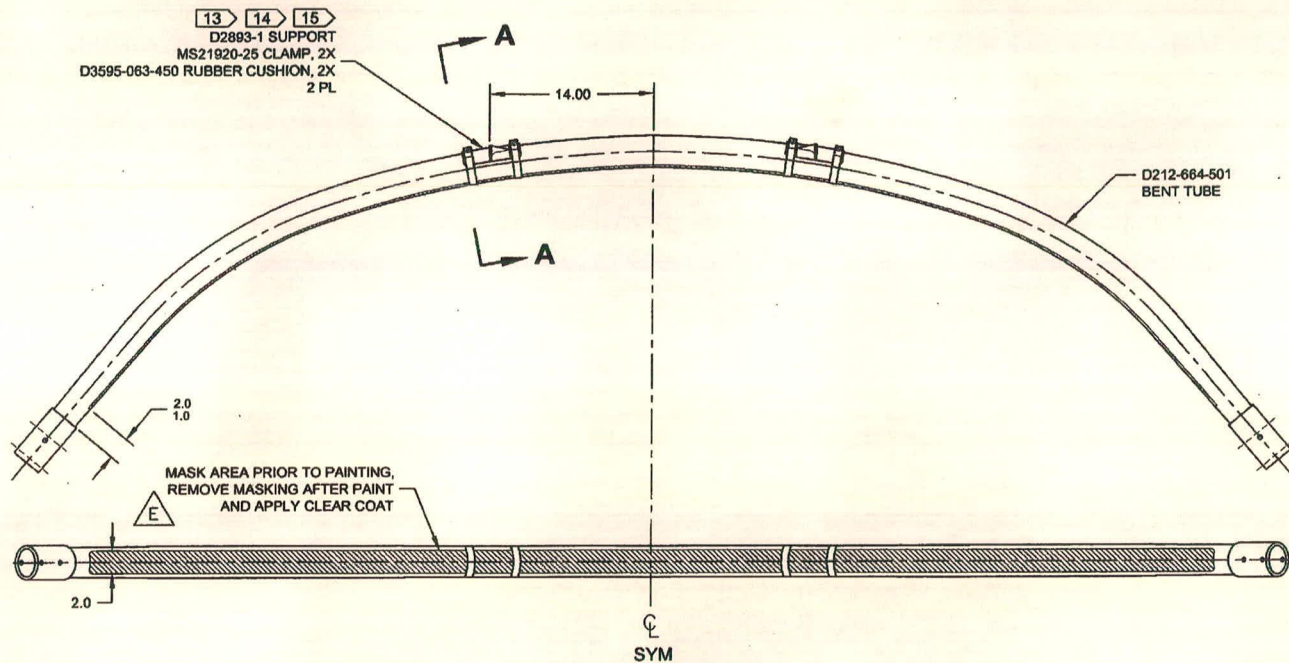
RELEASED
2014-05-26
WD

E	ADD -141F, D5017-1 WAS D2893-1 (-141B), PROSEAL WAS MAGNOBOND, NOTE 2: ADD INSPECTION WINDOW, NOTE 11: ALLOW 7.2% CRUSH, NOTE 15: ADD 72HR CURE AND RETORQUE FOR PROSEAL, ADD SHEET 3, CLAMPS REVERSED TO PREVENT CHAFING (B7-2, B7-3), BEND HEIGHT TOL. NOW 0.25 WAS 0.13 (C1-3), INCORP. DEC D-1/2/3	CP	14.04.01
D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	P		
DRAWN	P		
CHECKED	DW		
MFG. APPR.	[Signature]		
APPROVED	[Signature]		
DE APPR.	[Signature]		
DATE	14.04.01		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. E
D212-664-141 SHEET 1 OF 5
TITLE SCALE
XTUBE ASSY (205/212/412 HI FWD) NTS

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SECTION A-A
SCALE 4X

D212-664-141/-141F
ASSEMBLY DETAIL

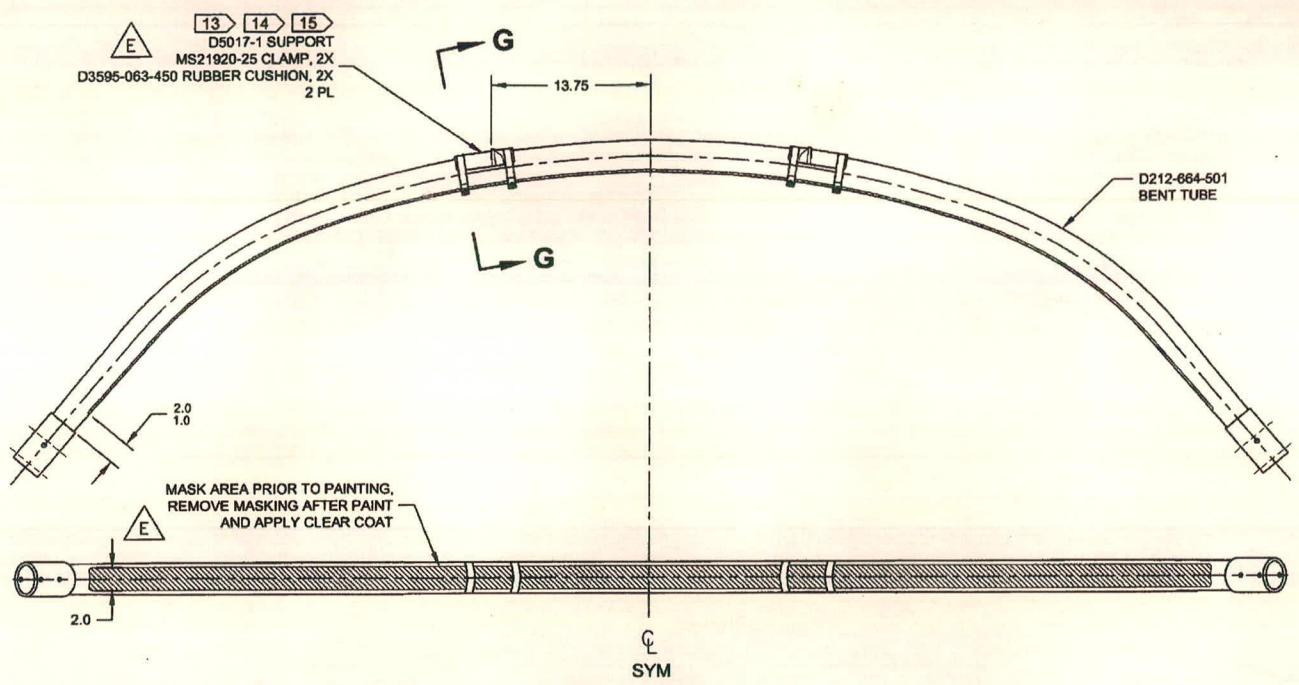
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2014-05-26
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DRAWN	Q	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. E
MFG. APPR.	Q	D212-664-141	SHEET 2 OF 5
APPROVED	Q	TITLE	SCALE
DE APPR.	Q	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
DATE	14.04.01	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

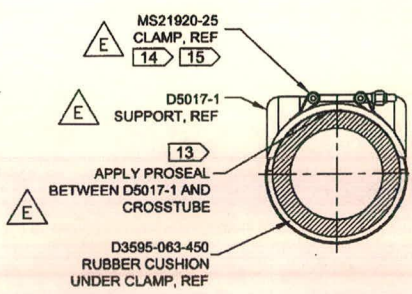
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D
C
B
A

D
C
B
A



D212-664-141B
ASSEMBLY DETAIL

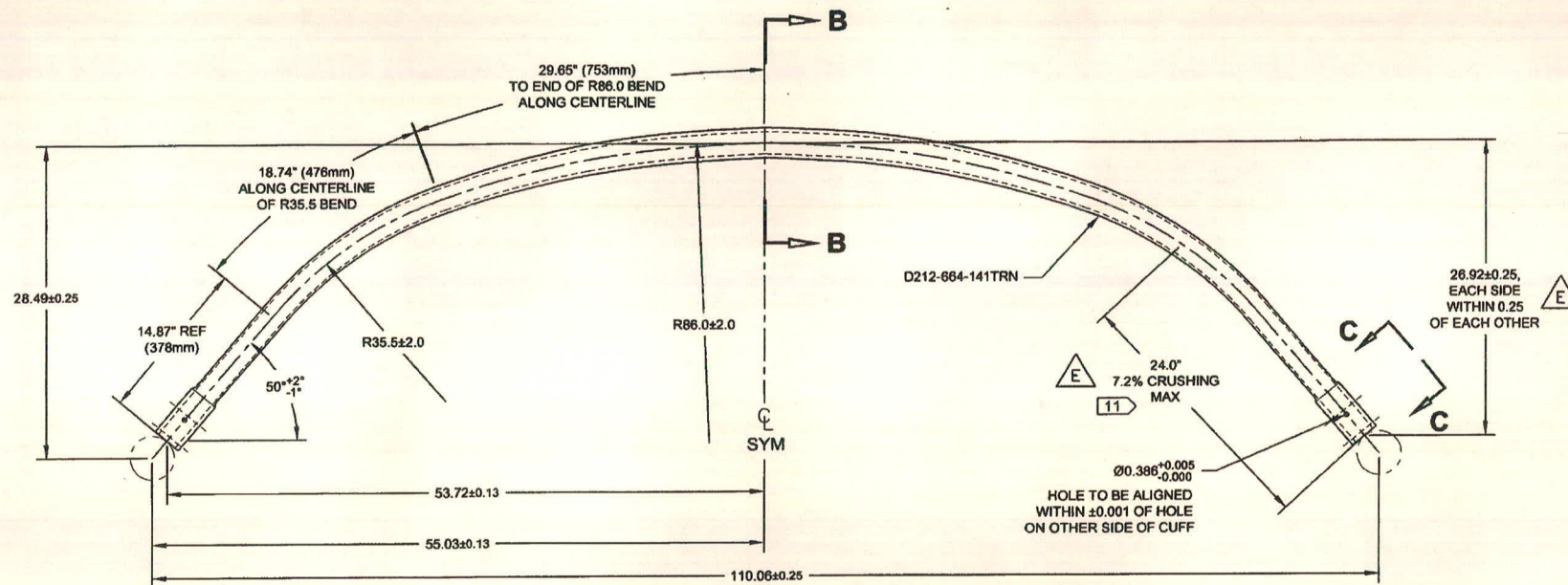


SECTION G-G
SCALE 4X

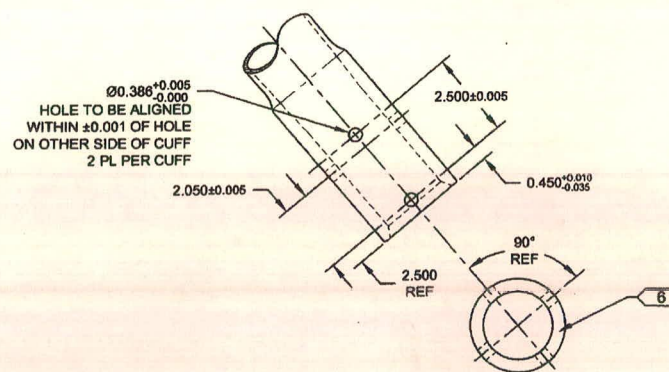
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2014-05-26

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DRAWN	<i>JP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DL</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>ML</i>	D212-664-141	SHEET 3 OF 5
APPROVED	<i>ML</i>	TITLE	SCALE
DE APPR.	<i>ML</i>	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
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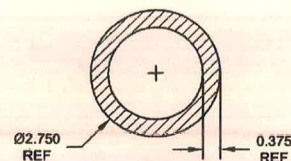
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D212-664-501
BENDING AND DRILLING DETAIL 11



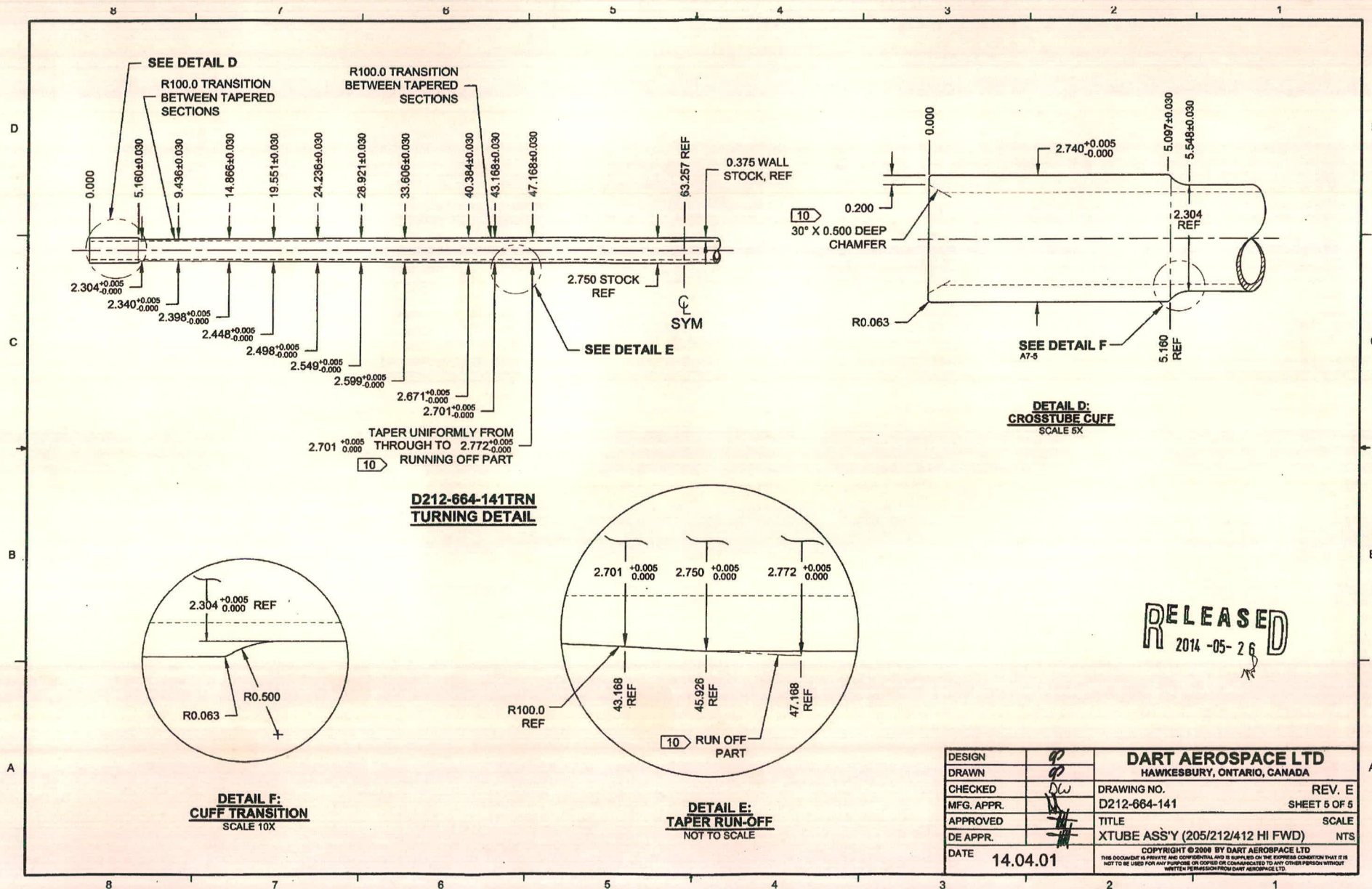
VIEW C-C: CUFF DETAIL
SCALE 3X



SECTION B-B
SCALE 4X

RELEASED
2014-05-26

DESIGN	42	DART AEROSPACE LTD	
DRAWN	42	HAWKESBURY, ONTARIO, CANADA	
CHECKED	42	DRAWING NO.	REV. E
MFG. APPR.	42	D212-664-141	SHEET 4 OF 5
APPROVED	42	TITLE	SCALE
DE APPR.	42	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
DATE	14.04.01	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041680**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO041680
PO Date: 11/12/18
Due Date: 11/20/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments: Please confirm pricing, and delivery to
ctsimiklis@dartaero.com

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181671	D350-748-203	AS350 / AS355 Stainless Steel Aft Crosstube : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 ISSUE P/O TO SKY SERVICE:	Firmed	-	11/20/18	1 pcs	0 pcs	1 pcs	\$182.14285/pcs	\$182.14
	181668			Firmed	-	11/20/18	1 pcs	0 pcs	1 pcs	\$182.14285/pcs	\$182.14
Sub Total:							2	0	2		\$364.29
2	184649	D212-664-101	Fwd Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	11/20/18	1 pcs	0 pcs	1 pcs	\$182.14285/pcs	\$182.14
	184650			Firmed	-	11/20/18	1 pcs	0 pcs	1 pcs	\$182.14285/pcs	\$182.14
	184696			Firmed	-	11/20/18	1 pcs	0 pcs	1 pcs	\$182.14285/pcs	\$182.14
Sub Total:							3	0	3		\$546.43



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041680**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	185756	D350-748-103	AS350 / AS355 Stainless Steel Fwd Crosstube : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 ISSUE P/O TO SKY SERVICE: _____	Firmed	-	11/20/18	1 pcs	0 pcs	1 pcs	\$182.14285/pcs	\$182.14
4	184242	D4464-041	Fuel Tank Assembly : Various STC's ISSUE P/O : _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	11/20/18	1 pcs	0 pcs	1 pcs	\$182.14285/pcs	\$182.14
Grand Total:										\$1,275.00	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/12/18 4:02 PM dart.tsimiklis.chrisoula

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO38124	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: P6 041680
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	

Task: UNSCHEDULED

Sequence: 1

Work Required:**CARRY OUT NDT ON:**

1 FUEL TANK ASSY, P/N# D4464-041, J/S# 184242 ✓

3 FWD CROSSTUBES, P/N# D212-664-101, J/S# 184649, 184650, 184696 ✓

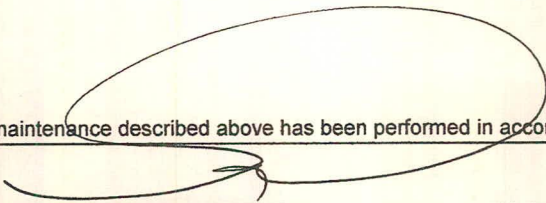
1 FWD CROSSTUBE, P/N# D350-748-103, J/S# 185756 ✓

2 AFT CROSSTUBES, P/N# D350-748-203, J/S# 181671, 181668 ✓

Action Taken:	Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417 REV. 16 NO CRACK OR LEAK FOUND PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923, DEV. MPO11715 , UV LIGHT M-20142	NOV 12 2018	 

Description	Location	P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: NOV 12 2018
Name: RAFIK MELIKJAN		

Change Record

PAGE 1 OF 1

Part Number: D212-664-101/-101MB

Description: CROSSTUBE INSTALLATION, HIGH FWD

[illegible]

